

# Work Order ID 58804

Wednesday, May 19, 2010 9:22:31 AM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 5/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

5/19/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

*Handwritten:* 10/06/10

*Handwritten:* 5/19/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 &amp; DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8863 and cut as per dwg D2750. Deburr.

4- Drill fwd step holes using DT9616. Ensure proper positioning.

5-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

6- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

7-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

8-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

9-Open up holes of Detail J to 0.297" (total of 2 holes per side)

10-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

Batch: m112860

BE 10/05/26

DP

10-5-25

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Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11-Grind welds flush as per Dwg D2750

12- scribe batch #.

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

H 10/5/26

S 10/5/26

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/5/26

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00				1	10/5/26		
	Hand Finishing								
150	QC3- Inspect Part Finish	0.00							
	QC	0.00				1	0	BE 10/05/26	
	Quality Control								

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> Sikaflex-291 batch: <u>M112425</u> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> exp. date: <u>10/18/20</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> Aluminum Rod batch: <u>M112860</u> <u>BE 10/05/27</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404" <u>BE 10/05/27</u>								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

M 10/5/26

M 10/5/31

# Dart Aerospace Ltd

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

dwg D2750

12-Deburr holes

H 107611

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

81060601

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

81060601

Memo

0.00

②

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	0.00							
Hand Finishing	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
Powder Coating	Memo START TIME: 8:00 AM OVEN TEMPERATURE: 320°F FINISH TIME: 9:30 AM								
210	QC3- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Memo Inspect for foreign object per QSI 024								

1 BK 10-6-2.

(1) 10/06/07

m 10 06 08 (1)

# Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
HandFinish	Memo	0.00				m/l	10	06	08 ①
Hand Finishing	Install inserts as per dwg D2750								
230	HandFinishing	0.00							
HandFinish	Memo	0.00				m/l	10	06	08 ①
Hand Finishing	1-Inspect for Foreign Objects								
	<del>2-Spray inside of tube with "LPS-3" batch:</del> N/A m/l 10-06-08								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 113435 EXP DATE: 10/11								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 114189								
	5-Coat all exposed fasteners with "LPS Procyon", batch: 104251								

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	S 1060609						
250  Packaging Packaging	Pick Kit  Memo	0.00 0.00				10-6-98			
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00	S 1060610						

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
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Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

*Per H*

*10-6-10 SF*

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

*10/06/10 JF*

*UMF*

*10-6-10*

*B58804*

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐  
IPP Rev: J 06-03-29 As per Rev D EC  
IPP Rev: K 06-07.13 As per dsi9343 EC  
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

220

Each

7,062.000

38



Insert

Location

Loc Qty

Loc Code

PK011

7062

110768

7062

AN3C5A

Purchased

No

230

Each

453.0000

34



Bolt

Location

Loc Qty

Loc Code

ST350

325

114330

125

114523

200

ST351

128

113121

10

114108

45

114181

73

AN3C6A

Purchased

No

230

Each

565.0000

4



BOLT

Location

Loc Qty

Loc Code

ST351

565

111982

565

mt 10.06.08

mt 10.06.08

mt 10.06.08

**Dart Aerospace Ltd**

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 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 101.0000 4



BOLT

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST344	99	
111649	2	
114455	47	
114653	50	

*nm 10.06.08*

AN8C35A Purchased No 230 Each 56.0000 1



BOLT

Location	Loc Qty	Loc Code
FP	6	
110847	6	
ST346	50	
114442	50	

*nm 10.06.08*

*★ NAS1149C0332R B#114341 nm 10.06.08*

~~AN960C10L~~ Purchased No 230 Each 0.0000 38



washer

AN960C816L Purchased No 230 Each 106.0000 1



WASHER

Location	Loc Qty	Loc Code
ST348	106	
110584	100	
111424	6	

*nm 10.06.08*

*nm 10.06.08*

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Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 146.0000 8



Bushing

Location	Loc Qty	Loc Code
ST023	146	
52311	69	
57914	77	

*mm 10.06.08*

D3488-042 Manufactured No 230 Each 19.0000 1



Blade Fitting Assembly, RH

Location	Loc Qty	Loc Code
FP008	19	
53918	19	

*mm 10.06.08*

D3492-041 Manufactured No 230 Each 98.0000 8



Plug Assembly

Location	Loc Qty	Loc Code
FP013	98	
57915	38	
58180	60	

*mm 10.06.08*

D3492-043 Manufactured No 230 Each 61.0000 8



Plug Assembly

Location	Loc Qty	Loc Code
FP	2	
54682	2	
FP013	59	
57916	59	

*mm 10.06.08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 58804



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3535-25 Manufactured No 230 Each 13.0000 1



Wearshoe

Location Loc Qty Loc Code  
 FP18 13

57943 13

D3536-25 Manufactured No 230 Each 6.0000 1



Gasket

Location Loc Qty Loc Code  
 FP12 6

57944 6

D3537-1 Manufactured No 230 Each 24.0000 3



Wearpad

Location Loc Qty Loc Code  
 FP 1

55465 1

FP17 23

57256 23

D3631-1 Manufactured No 230 Each 206.0000 8



Washer

Location Loc Qty Loc Code  
 ST076 206

52693 206

B# 54388

*10.06.08*

*10.06.08*

*10.06.08*

*10.06.08*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 58804



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No 230 Each 1,375.000 4



Phenolic Washer

Location	Loc Qty	Loc Code
ST077	1375	
51674	375	
52505	1000	

*nm* 10.06.08

D3791-1 Manufactured No 230 Each 5.0000 1



Wearplate

Location	Loc Qty	Loc Code
FP17	5	
56299	5	

*nm* 10.06.08

D3793-1 Manufactured No 230 Each 10.0000 1



Wearshoe

Location	Loc Qty	Loc Code
FP18	10	
56300	1	
57945	9	

*nm* 10.06.08

D3793-3 Manufactured No 230 Each 11.0000 1



Wearshoe

Location	Loc Qty	Loc Code
FP19	11	
57947	11	

*nm* 10.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 58804



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3794-1 Manufactured No 230 Each 32.0000 1



Gasket



Location Loc Qty Loc Code

FP010 26

57942 26

FP014 6

57537 6

D3794-3 Manufactured No 230 Each 14.0000 1



Gasket



Location Loc Qty Loc Code

FP18 14

56066 14

MS21043-6 Purchased No 230 Each 826.0000 4



NUT



Location Loc Qty Loc Code

ST301 826

112314 826

MS21083C8 Purchased No 230 Each 41.0000 1



NUT



Location Loc Qty Loc Code

ST303 41

113845 11

114523 30

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*MW 10.06.08*

*B# 59153*

*MW 10.06.08*

*MW 10.06.08*

*MW 10.06.08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 7

Work Order ID: 58804

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
IPP Rev: J 06-03-29 As per Rev D EC  
IPP Rev: K 06-07.13 As per dsi9343 EC  
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased No

230

Each

306.0000

8



O-RING

Location

Loc Qty

Loc Code

FP

306

110715

100

110915

206

NAS1611-013

Purchased No

230

Each

223.0000

8



O-RING

Location

Loc Qty

Loc Code

FP

223

114451

185

114496

38

AN8C21A

Purchased No

250

Each

113.0000

2



BOLT

Location

Loc Qty

Loc Code

ST345

113

111605

23

113558

50

114653

40

AN960C816L

Purchased No

250

Each

106.0000

1



WASHER

Location

Loc Qty

Loc Code

ST348

106

110584

100

111424

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 58804

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
IPP Rev: J 06-03-29 As per Rev D EC  
IPP Rev: K 06-07.13 As per dsi9343 EC  
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D2741 Manufactured No 250 Each 28.0000 1

Blade, 350 Skidtube

Location Loc Qty Loc Code  
ST466 28

55905

28

D3493-1 Manufactured No 250 Each 33.0000 2

Washer

Location Loc Qty Loc Code  
ST065 33

57825

33

D3532-1 Manufactured No 250 Each 25.0000 2

Spacer

Location Loc Qty Loc Code  
ST068 25

52321

25

D3672-13 Purchased No 250 Each 894.0000 2

Phenolic Washer

Location Loc Qty Loc Code  
ST077 894

54363

894

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 9

Work Order ID: 58804

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

250 Each

41.0000

1



NUT



10-6-95

## Location

## Loc Qty

## Loc Code

ST303

41

113845

11

114523

30

D2600-3-BENT

Manufactured No

110

Each

2.0000

1



Extrusion Bent



7

## Location

## Loc Qty

## Loc Code

LG

2

55462

57538

1

D2744

Manufactured No

110

Each

28.0000

1



Cap



10-5-25

## Location

## Loc Qty

## Loc Code

LG

28

47488

10

51922

18

D2739

Manufactured No

160

Each

1.0000

1



350 I Beam



BE 10/25/26

## Location

## Loc Qty

## Loc Code

LG

1

57948

1

1358213 10/5/26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 58804



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 114.0000 8



Crossbolt Spacer



Location Loc Qty Loc Code

LG 114  
 50281 10  
 52310 24  
 57953 80

D3490-3 Manufactured No 160 Each 31.0000 4



Cross Bolt Spacer



Location Loc Qty Loc Code

LG 31  
 57918 31

D3490-1 Manufactured No 160 Each 25.0000 4



Cross Bolt Spacer



Location Loc Qty Loc Code

LG 25  
 57723 25

8 BE 10/05/27

4 BE 10/05/27

4 BE 10/05/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

## GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58804  
BS10-5-19

RELEASED  
08-07-16

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2750	SHEET 1 OF 11
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS
COPYRIGHT © 1993 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

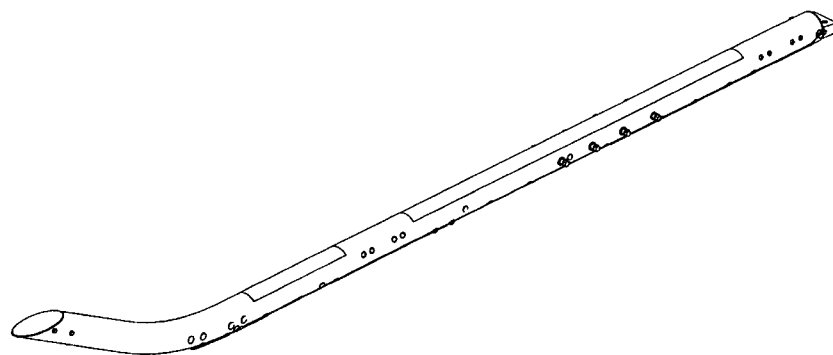
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

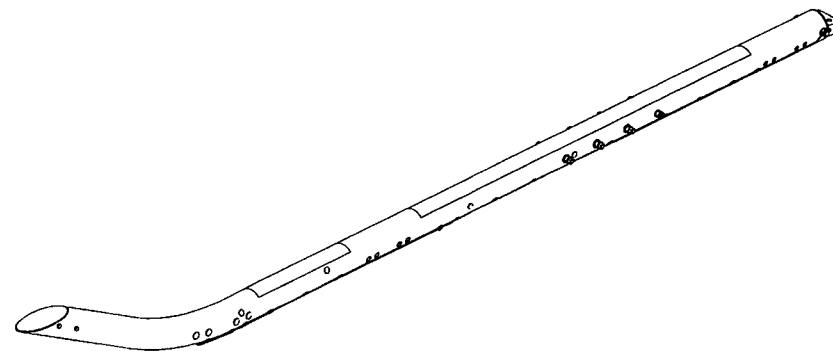
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

W/O 58804

**RELEASED**  
08.09.22

DESIGN	PCY	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	AM	DRAWING NO.	REV. F
MFG. APPR.	AM	D2750	SHEET 2 OF 11
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

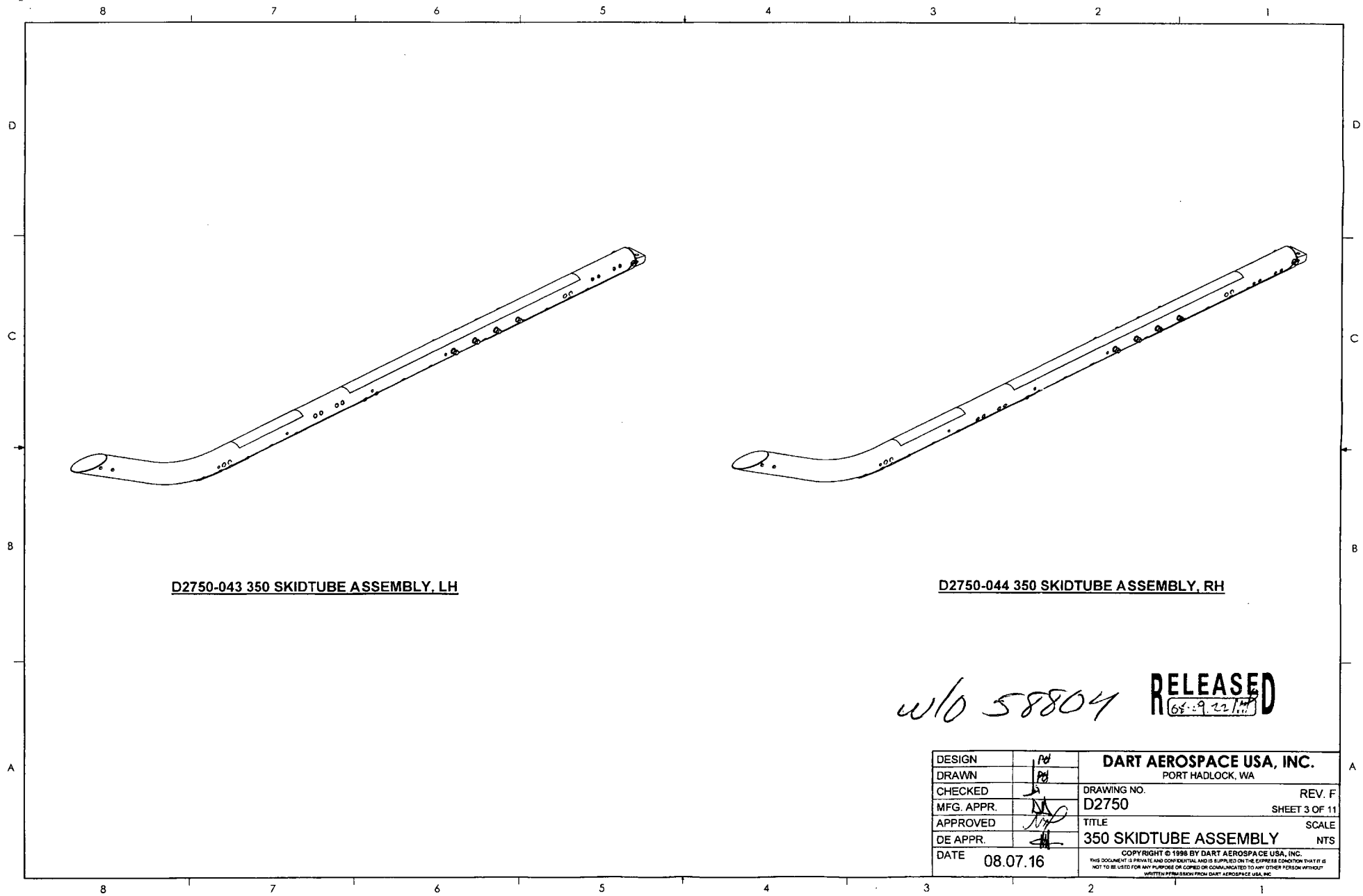
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

w/o 58804 **RELEASED**  
68-9-22/111

DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	MA	SHEET 3 OF 11	
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	<b>350 SKIDTUBE ASSEMBLY</b> NTS	
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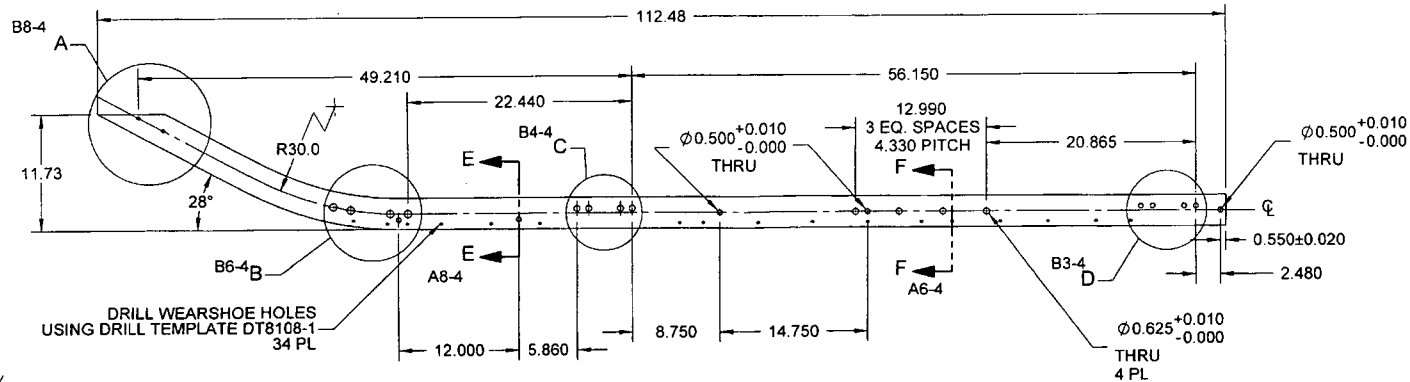
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

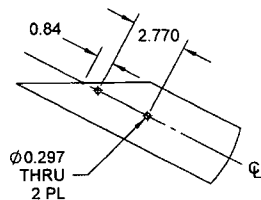
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

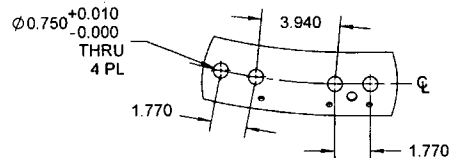
**NOTE:** Date & initial all entries



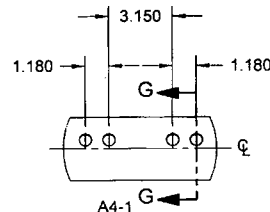
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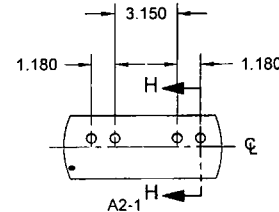
**DETAIL A**  
SCALE 2X



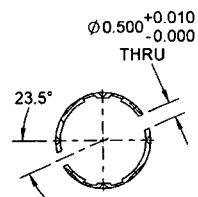
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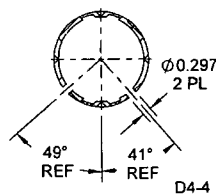
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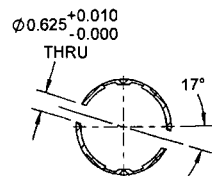
**DETAIL D**  
SCALE 2X



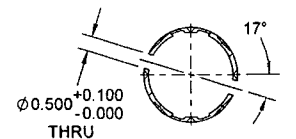
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN	IPB
DRAWN	IPB
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.07.16

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F  
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS  
SHEET 4 OF 11

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*W/058804*

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08.22.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

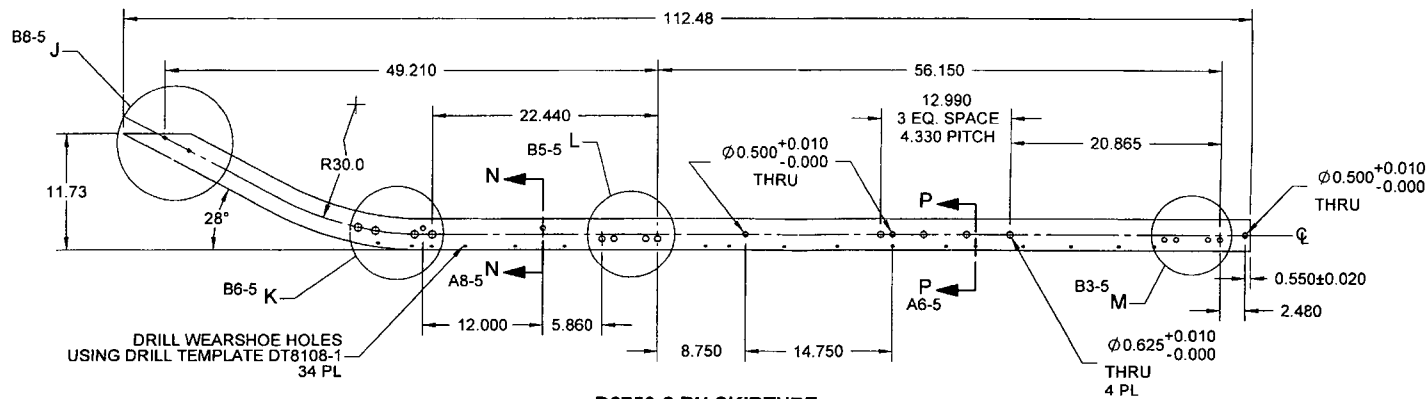
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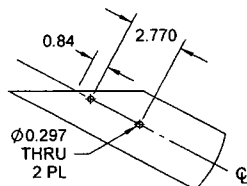
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

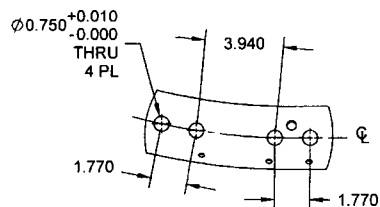




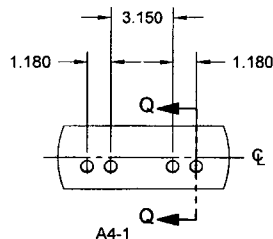
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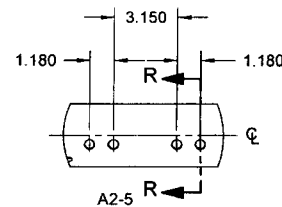
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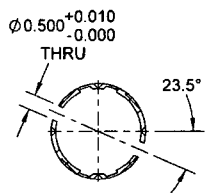
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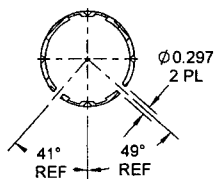
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SCALE 2X



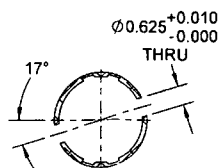
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SCALE 2X



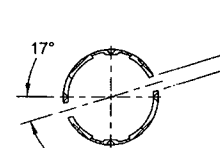
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.		TITLE	SHEET 5 OF 11
APPROVED		<b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

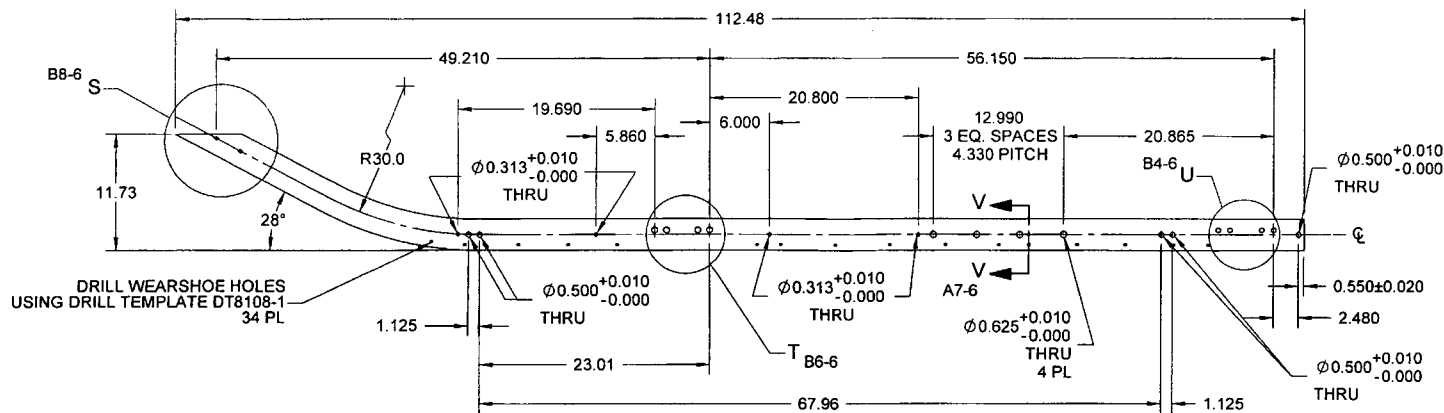
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

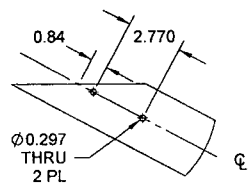
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

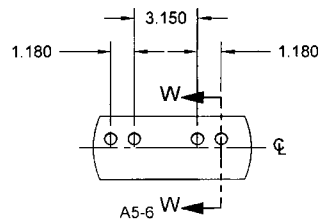
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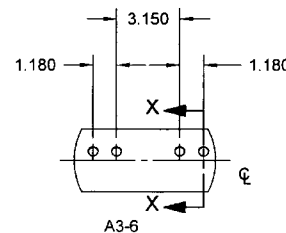
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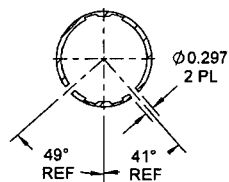
**DETAIL S**  
SCALE 2X



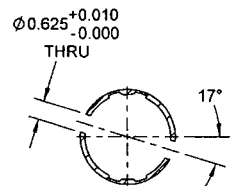
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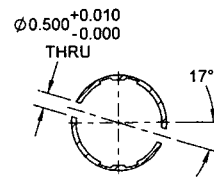
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

w/o 58804

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DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.		SHEET 6 OF 11	
APPROVED		TITLE	SCALE
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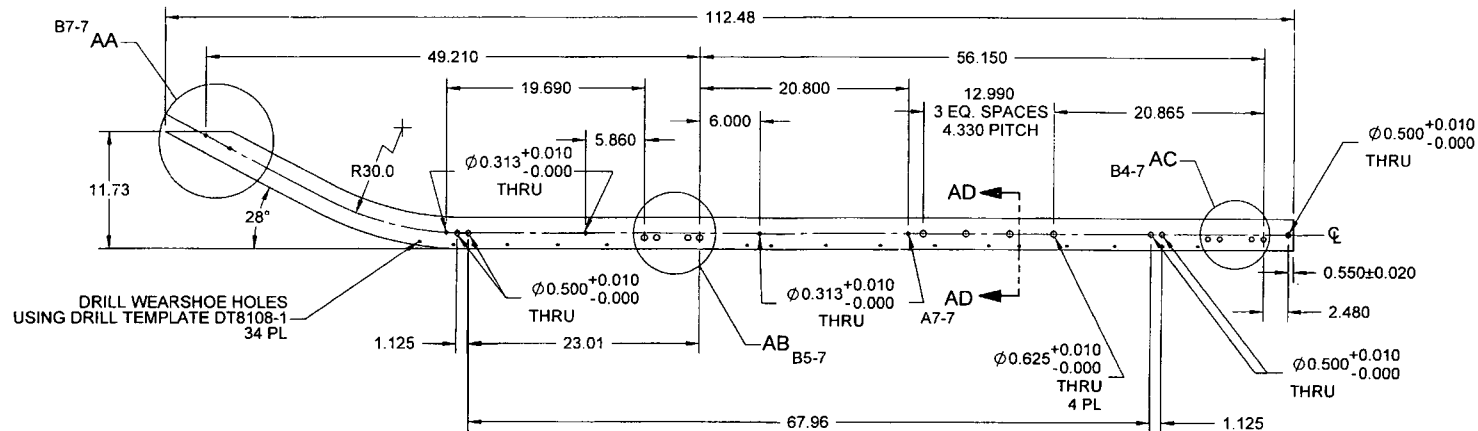
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

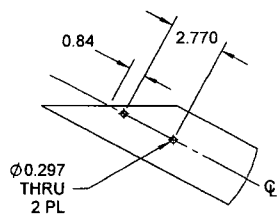
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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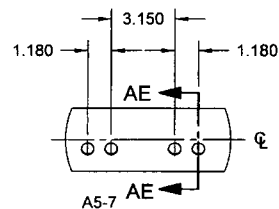
**NOTE:** Date & initial all entries



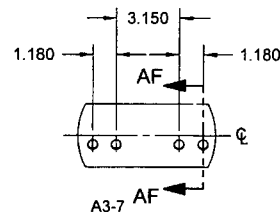
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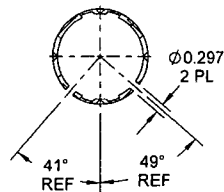
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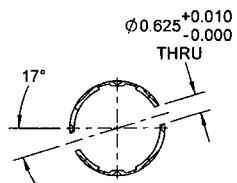
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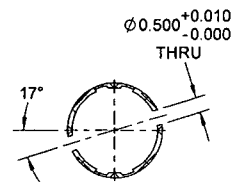
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

W/0 58804

**RELEASED**  
06-22-11

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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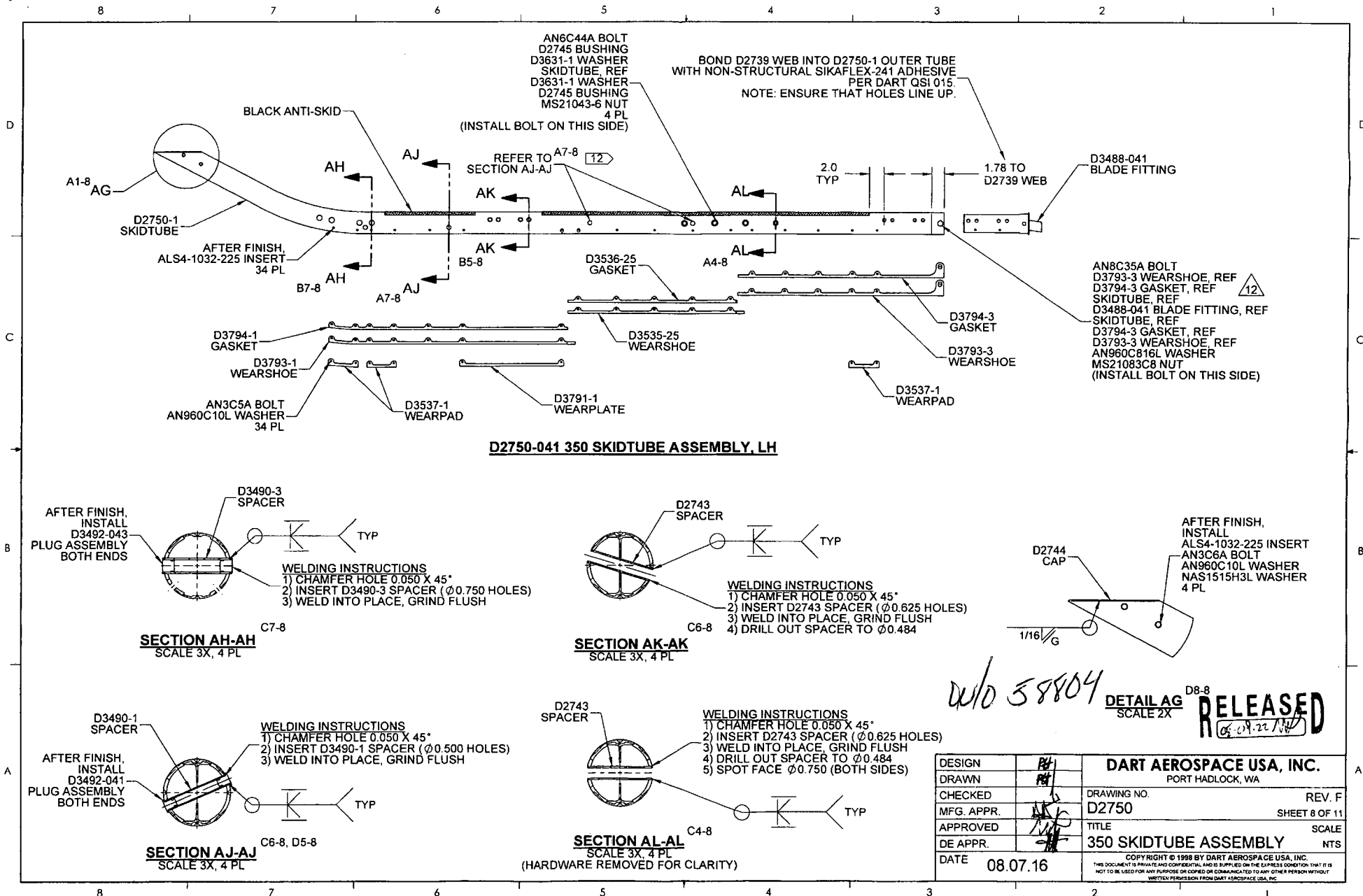
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





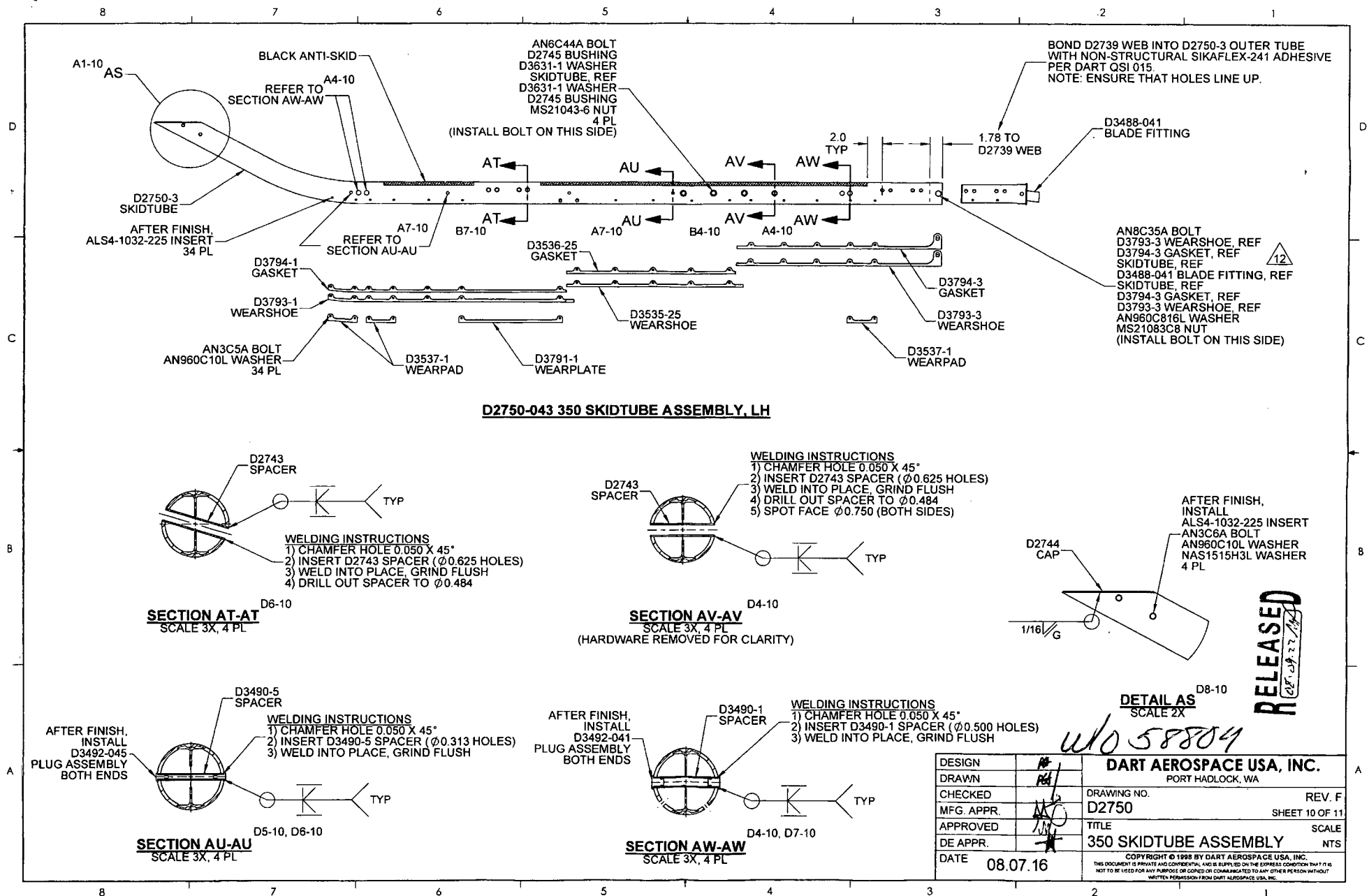
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2750-043 350 SKIDTUBE ASSEMBLY, LH**

**SECTION AT-AT**  
SCALE 3X, 4 PL

**WELDING INSTRUCTIONS**  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.484

**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

**WELDING INSTRUCTIONS**  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.484  
5) SPOT FACE Ø0.750 (BOTH SIDES)

**SECTION AU-AU**  
SCALE 3X, 4 PL

**WELDING INSTRUCTIONS**  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

AFTER FINISH, INSTALL D3492-045 PLUG ASSEMBLY BOTH ENDS

**SECTION AW-AW**  
SCALE 3X, 4 PL

**WELDING INSTRUCTIONS**  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY BOTH ENDS

**DETAIL AS**  
SCALE 2X

AFTER FINISH, INSTALL ALS4-1032-225 INSERT AN3C6A BOLT AN960C10L WASHER NAS1515H3L WASHER 4 PL

DESIGN	REV. 1	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	REV. 1	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

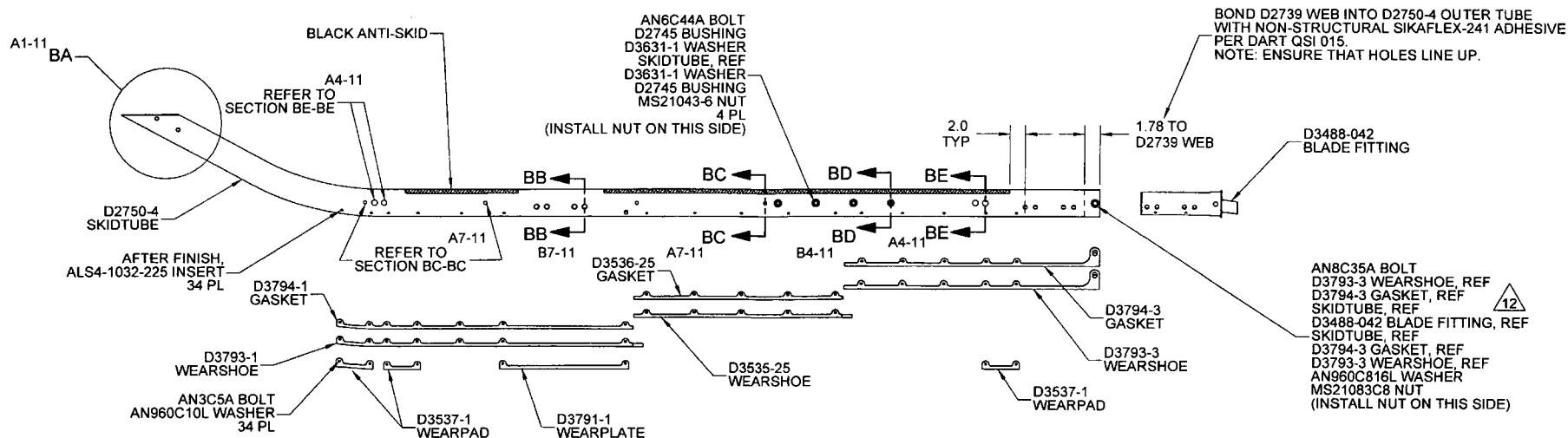
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

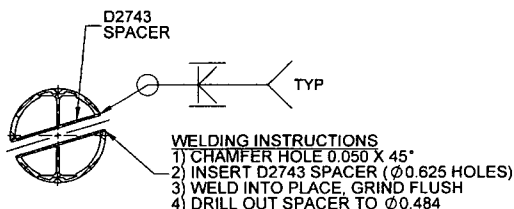
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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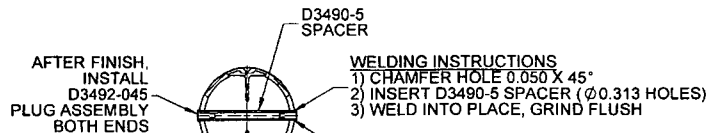
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



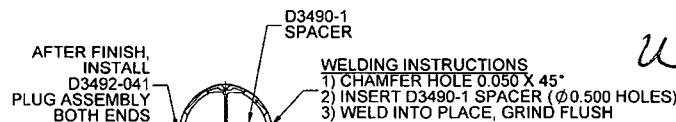
**SECTION BB-BB**  
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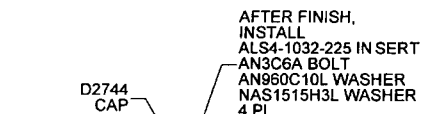
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

**RELEASED**  
08-07-16

DESIGN	W/0 58804	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	W/0 58804	PORT HADLOCK, WA	
CHECKED	W/0 58804	DRAWING NO.	REV. F
MFG. APPR.	W/0 58804	<b>D2750</b>	SHEET 11 OF 11
APPROVED	W/0 58804	TITLE	SCALE
DE APPR.	W/0 58804	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 233

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barday Elliott  
Job number: 58816  
Part number: D350-686 014  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat. Dunn Date of Test Coupon 10.06.01

Welder Barday Elliott Date of Test Coupon 10.06.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld